

# Work Order ID 91162

October-03-12 9:08:19 AM

**\*91162\***

Page 1

Item ID: D2680-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Nut Plate

Start Date: 03/10/2012 Start Qty: 80.00

**\*80\***

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 80.00

**\*80\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2680	Rev B1								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2680 Dwg Rev: <u>B1</u> Prog Rev: <u>B1</u> 2-								
1010.063	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

(90)

FB12-10-11

(90)

FB12-10-11

90  
cont

Smb  
12/10/12

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Required Date: 12/11/2012 Req'd Qty: 80.00

**\*80\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab					90x			12/11/13
Small Fab	Memo	0.00							
Small Fab	1- Deburr 2-C'sink as per Dwg D2680								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O	0.00				90			
QC	Memo	0.00				cont			
Quality Control									
150		0.00							
<b>*150*</b>	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				90X			12/11/14
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:45								
	FINISH TIME: 11:15								

ml 22878

4000 F

11:15

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Item ID: D2680-041

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Nut Plate

Start Date: 03/10/2012 Start Qty: 80.00

\*80\*

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 80.00

\*80\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
*160*									
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							
*170*									
Small Fab	Memo	0.00							
Small Fab	Install Nut Plate as per Dwg D2680								
180	QC5- Inspect part completeness to step on W/O	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

90x f M u / u / r

90x

90x  
Cant

12/11/20

DAS  
15  
8-8  
101121

90  
Cant

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Required Date: 12/11/2012 Req'd Qty: 80.00

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>014</u>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

Ca 12/4/12 (90)12/11/2012ME  
12-11-29

# Picklist Print

October-03-12 9:08:22 AM

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Work Order ID: 91162

\*91162\*

Parent Item: D2680-041

\*D2680-041\*

Parent Item Name: Nut Plate

Start Date: 03/10/2012

Required Date: 12/11/2012

Start Qty: 80.00

Required Qty: 80.00

## Comments:

IPP: D04.10.01Added Steps 2-4, 7-8KJ/JLM  
IPP Rev:E Now on WaterJet 06-10-12 JLM  
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21069L4 *MS21069L4* Nutplate		Purchased	No			110	Each	91.0000	1	80			
				<u>Location</u>				<u>Loc Qty</u>					
				ST302				41					
					119042			41					
				ST303				50					
					120498			50					
M1010S16GA *M1010S16GA* 1010/1025 sheet 16GA		Purchased	No			170	sf	116.3000	0.0131	1.103158			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT				116.3					
					111410			0					
					122455			116.3					
MS20426AD3-3 *MS20426AD3-3* Rivet		Purchased	No			170	Each	13,664.75	2	160			
				<u>Location</u>				<u>Loc Qty</u>					
				ST316				1470					
					119109			282					
					121011			771					
					19099			417					
				ST334				12194.75					
					122814			12194.75					

*Handwritten notes and signatures:*

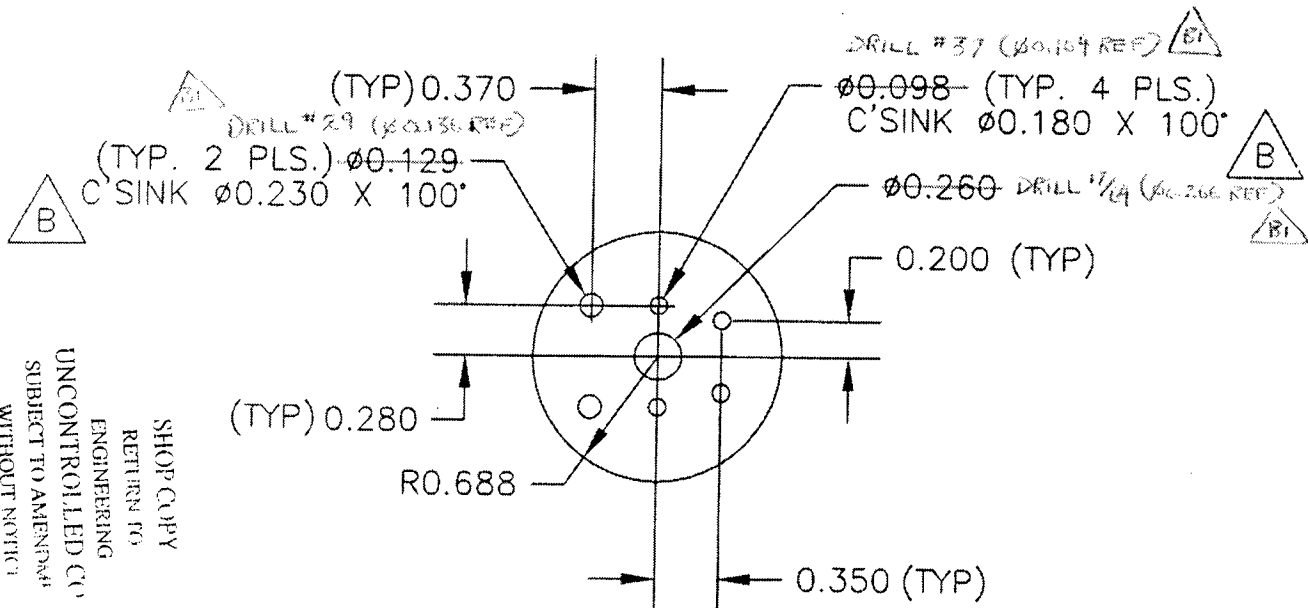
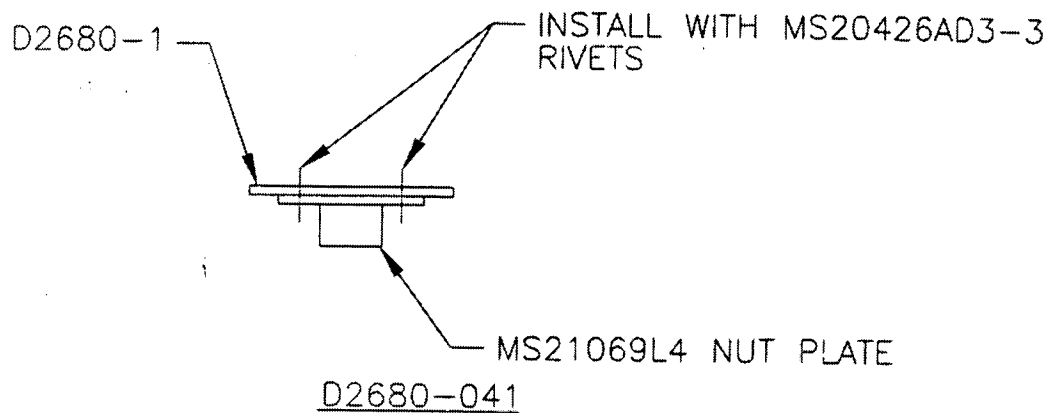
- Signature: *[Signature]*
- Date: *12/11/20*
- Quantity: *1123265 (900)*
- Date: *12-10-11*
- Quantity: *122455*
- Signature: *[Signature]*
- Date: *12/11/20*
- Quantity: *180*





DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED P	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	04.11.04	CHANGE HOLES & FINISH	

RELEASED  
18.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

POWDER COAT WHITE (4.75.2) PER DART QSI 005 4.3

D2680-1